

Date: Wednesday, 2/20/2008 4:22:52 PM  
 User: Kim Johnston

## Process Sheet

10

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SADDLE KIT		
Job Number	: 37536			Part Number	: K10003		
Estimate Number	: 10532			Drawing Number	: K10003		
P.O. Number	:			Project Number	: N/A		
This Issue	: 2/20/2008 S.O. No. :			Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 3/5/2008		
Previous Run	: 37280			Qty:	8 Um: Each		
Written By	:						
Checked & Approved By	: <u>080221</u>						
Comment	: Est: I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF Est: J 06-07-25 As per DSI 9344 JLM Est: K 06.11.17 Per K10003 Rev C KJ Est Rev: L 07.01.12 Document Record for copying bluefile rmv KJ						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL 
Comment: DOCUMENT CONTROL Create White labels only per PPP K10003		CHG 005 
2.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Pick Packing Kit		
3.0	D2570 	Bushing 
Comment: Qty.: 24.0000 Each(s)/Unit Total : 192.0000 Each(s) Bushing Pick: Qty Part Number Description Batch 24 D2570 Bushing <u>36480</u>		
4.0	D2571 	Saddle, Fwd, Out 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Saddle, Fwd, Out Pick: Qty Part Number Description Batch 1 D2571 Saddle <u>36322</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D2572 Saddle, Fwd, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle, Fwd, In

OK

335932 44

Pick:

Qty	Part Number	Description	Batch
1	D2572	Saddle	37283 44

6.0 D2573 Saddle, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle, Aft, Out

3X

335933 3X

Pick:

Qty	Part Number	Description	Batch
1	D2573	Saddle	37283 44

7.0 D2574 Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle, Aft, In

3X

335933 3X

Pick:

Qty	Part Number	Description	Batch
1	D2574	Saddle	37567 24

37553 3X

8.0 D27361 Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Lug Assembly

3X

335933 3X

Pick:

Qty	Part Number	Description	Batch
1	D2736-1	Bracket	36330

9.0 D27363 Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Lug Assembly

3X

335933 3X

Pick:

Qty	Part Number	Description	Batch
1	D2736-3	Bracket	35064 3X

37154 5X

208/3/13 FJ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: K10003

Job Number:



Seq. #:	Machine Or Operation:	Description :
10.0	D2747	Set Screw 
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s) Set Screw Pick: Qty Part Number Description Batch 4 D2747 Socket Head Set Screw 36331
11.0	D2876	Saddle Spacer 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s) Saddle Spacer Pick: Qty Part Number Description Batch 2 D2876 Spacer 133543
12.0	D2877	Saddle Spacer 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s) Saddle Spacer Pick: Qty Part Number Description Batch 2 D2877 Spacer 37818
13.0	D2968041	Tow Ring 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Tow Ring Pick: Qty Part Number Description Batch 1 D2968-041 Tow Ring 31957
14.0	D35331	Set Screw 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s) Set Screw Batch: B28U93
15.0	AN46A	Bolt 
		Comment: Qty.: 16.0000 Each(s)/Unit Total : 128.0000 Each(s) Bolt Pick: M105810

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty	Part Number	Description	Batch
16	AN4-6A	Bolt	_____

16.0 AN446A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
4	AN4-46A	Bolt	M106277

17.0 AN451A Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN4-51A	Bolt	M106662

18.0 AN612A Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN6-12A	Bolt	M106513

19.0 AN960JD416 Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 256.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
32	AN960JD416	Washer	M106277

20.0 AN960JD616 Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
8	AN960JD616	Washer	M106883

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/03/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty Part Number  
1 AN970-4

Description  
Washer

Batch  
M105442

*CR*

22.0

MS21042L4

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 232.0000 Each(s)

Nut

Pick:

Qty Part Number  
29 MS21042L4

Description  
Nut (or MS21042-4)

Batch  
105938

*CR 08/3/13 (8)*

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PKG.

*AS 08/03/17 (8)*

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*AS 08/03/15*

Job Completion



*2008/3/17 (8)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**DART**

DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>TH</i>	DRAWING NO. K10003	REV. C SHEET 1 OF 1
DATE 06.11.07		TITLE SADDLE KIT	SCALE NTS
A	00.06.01	NEW ISSUE	
B	00.11.22	ADD D2707-041 OPTION	
C	06.11.07	ADD D3533-1	

**RELEASED**06.11.07 *TH*

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 205/210/212/412	D205-634-011 D205-634-015
BELL 204	D204-635-011

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10003	D205-634-011 D205-634-015	D204-635-011
D205-641-011	1	1	1 SHOP COPY
D2570	16	16	16 RETURN TO
D2571	1	1	1 ENGINEERING
D2572	1	1	UNCONTROLLED COPY
D2573	1	1	SUBJECT TO AMENDMENT
D2574	1	1	1 WITHDRAWAL NOTICE
D2747	4	4	4 " 31536
D2876	2	2	2 NO. <i>31536</i>
D2877	2	2	2
D2707-041 (or D2968-041)	1	1	1
D3533-1	2	2	2
AN4-51A	8	8	8
AN4-6A	16	16	16
AN6-12A	8	8	8
AN960JD416	32	32	32
AN960JD616	8	8	8
*AN960JD1016	1	1	1
AN970-4	1	1	1
MS21042-4 (OR L4)	25	25	25

\* REQUIRED WITH D2707-041 ONLY

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